

Work Order ID 62110

Thursday, September 16, 2010 8:58:32 AM

Page 1

Item ID: PB67-43001-277

Accept

Revision ID:

Item Name: Contoured Male Eye

Start Date: 9/16/2010 Start Qty: 6.00

Required Date: 9/30/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: UMFDate: 10-9-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.250" x 1.250" x 2.250" long

sub 10/10/116 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA544 and Dwg B67-43001

Identify as B67-43001-277

Dwg Rev CFolio Rev BB.A 10/10/046 0

Manually tap part as per Dwg B67-43001

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62110

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Item ID: PB67-43001-277

Accept



Setup Start



Revision ID:

Stop



Item Name: Contoured Male Eye

Start Date: 9/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Y.A 10/10/04

6

Ø

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 10/10/04

6

Ø

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

MK / 10-10-04

(6)

W/O:		WORK ORDER CHANGES					
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Item ID: PB67-43001-277

Accept



Setup Start



Revision ID:

Stop



Item Name: Contoured Male Eye

Start Date: 9/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05

MF
10-10-05

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 16, 2010 8:58:31 AM

Page 1

Work Order ID: 62110



Parent Item: PB67-43001-277



Parent Item Name: Contoured Male Eye

Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 05.07.19 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased		No		100	f	13.6290	0.1875	1.184211			



6061-T6 Bar 1.25 x 1.25

Location

MAT03

106259

→ 110001

Loc Qty

13.62895053

7.06921053

6.55974

Loc Code

1.184 *ml 10/10/01*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62110
Description: Contoured Male Eye		Part Number: PB67-43001-277
Inspection Dwg: PB6743001-277 Rev: C		Page 1 of 1

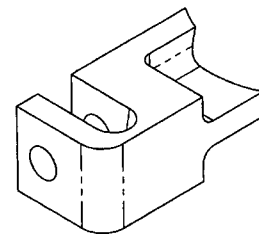
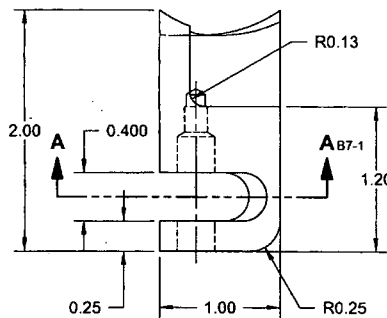
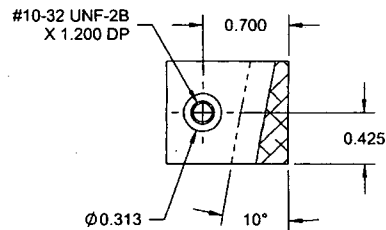
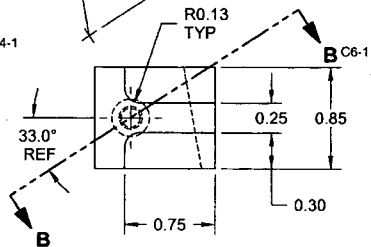
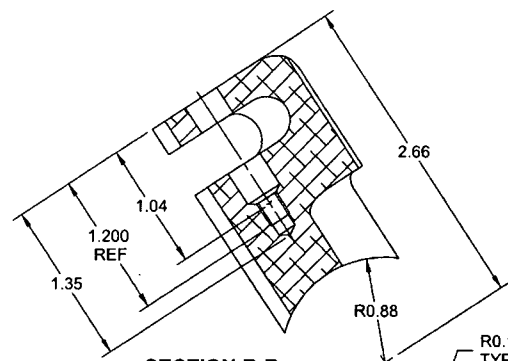
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.35	+/- .030	1.352	✓		Depth Gage	GA-08
RO.88	+/- .030	RO.880	✓		Rad Gage	ref.
0.700	+/- .010	0.698	✓		Vern	GA-01
0.425	+/- .010	0.424	✓		"	"
10°	+/- 1/2°	10°	✓		Angle meter	CNC-03
Ø0.313	+0.006/- .001	Ø0.315	✓		Vern	GA-01
2.00	+/- .030	2.000	✓		"	"
0.400	+/- .010	0.397	✓		"	"
0.25	+/- .030	0.251	✓		"	"
1.00	+/- .030	0.999	✓		"	"
RO.25	+/- .030	RO.250	✓		Rad gage	ref.
1.20	+/- .030	1.203	✓		Vern	GA-01
RO.13	+/- .030	RO.130	✓		Rad gage	ref.
0.75	+/- .030	0.752	✓		Vern	GA-01
0.30	+/- .030	0.302	✓		"	"
0.25	+/- .030	0.247	✓		"	"
0.85	+/- .030	0.850	✓		"	"
RO.13	+/- .030	RO.130	✓		Rad gage	ref.
33.0°	+/- 1/2°	33.0°	✓		Angle meter	CNC-03

Measured by: B.A.	Audited by:	Preliminary Approval:
Date: 10/10/04	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10:04:15



#62110

RELEASED
2009-09-24

B67-43001-277 CONTOURED MALE EYE

NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 20 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.24
DESIGN	DRAWN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	B67-43001-277	SHEET 1 OF 1
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	CONTOURED MALE EYE	NTS
DATE	09.02.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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